

HOW TO READ THE STANDARD OF HSK-T TOOLS

● How this section page is organized

① Organized by application. (Refer to the index on the next page.)

PRODUCT TYPE

indicates the first four letters of the order number, as well as cutting applications.

TITLE OF PRODUCT SERIES PRODUCT SECTION

HSK-T TOOLS FOR MULTI-TASK MACHINES

PCLN External turning • Facing

Finish	Light	Medium
FF	LF	MF
(F2)	(F2)	(F2)
Medium	Medium	Medium
Standard	Standard	Standard
BP	BP	BP
(F2)	(F2)	(F2)
Stainless	Stainless	Stainless
CBN	CBN	CBN
(F2)	(F2)	(F2)

Order Number	Stock	Insert Number	Dimension (mm)	Shim	Shim Pin	Clamp Lever	Clamp Screw	Wrench			
H63TH-PCLNR/L-DX12	R/L	CNNC CNGC NPN/CN/A	1204-□□	65	45	1.3	LLSCN42	LLP14	LLCL14	LLCS108	HKY30R

* Clamp Torque (N • m) : LLC5108-3.3

DCLN External turning • Facing **DOUBLE CLAMP type**

Finish	Light	Medium
FF	LF	MF
(F2)	(F2)	(F2)
Medium	Medium	Medium
Standard	Standard	Standard
BP	BP	BP
(F2)	(F2)	(F2)
Stainless	Stainless	Stainless
CBN	CBN	CBN
(F2)	(F2)	(F2)

Order Number	Stock	Insert Number	Dimension (mm)	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench			
H63TH-DCLNR/L-DX12	R/L	CNNC CNGC NPN/CN/A	1204-□□	65	45	1.3	LLSCN42	LLP14	DCX2613	DCS1	DC0621T	TKY20F

* Clamp Torque (N • m) : DC0621T-4.5

Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P Mild Steel	≤180HB	Finish Cutting	FY	NC3035	260~370
		Light Cutting	BY	NC3035	230~330
		Medium Cutting	MS	UE8110	260~440
Carbon Steel Alloy Steel	180HB~350HB	Finish Cutting	FN	NC3035	200~280
		Light Cutting	SH	UE8110	210~300
		Medium Cutting	MP	UE8110	190~325
M Stainless Steel	≤200HB	Finish Cutting	FN	US735	100~200
		Light Cutting	SH	US735	90~165
		Medium Cutting	MS	US735	85~165
K Gray Cast Iron	Tensile Strength 550MPa	Light Cutting	MA	UC3115	160~295
		Medium Cutting	Standard	UC3115	160~295
		Rough Cutting	Flat Top	UC3115	155~280

● : Inventory maintained in Japan.

PCLN type inserts > A66~A870
DCLN type inserts > A66~A870
CBN & PCD inserts > B922~B924, B952

LEGEND FOR STOCK STATUS MARK
is shown on the left hand page of each double-page spread.

REFERENCE PAGE FOR APPLICABLE INSERTS
indicates reference pages for details of inserts that are applicable to the title product.

PRODUCT STANDARDS
Indicates order numbers, stock status (per right/left hand), applicable inserts, dimensions, and spare parts.

FIGURE SHOWING THE TOOLING APPLICATION
uses illustrations and arrows to depict available machining applications along with cutting edge lead angles.

GOMETRY CHIP BREAKER BY CUTTING APPLICATION

PCMN External turning • Facing

Finish	Light	Medium
FF	LF	MF
(F2)	(F2)	(F2)
Medium	Medium	Medium
Standard	Standard	Standard
BP	BP	BP
(F2)	(F2)	(F2)
Stainless	Stainless	Stainless
CBN	CBN	CBN
(F2)	(F2)	(F2)

Order Number	Stock	Insert Number	Dimension (mm)	Shim	Shim Pin	Clamp Lever	Clamp Screw	Plug	Wrench		
H63TH-PCMNN-H12	●	CNNC CNGC NPN/CN/A	1204-□□	100	1.7	LLSCN42	LLP14	LLCL14	LLCS108	HGMPT118	HKY30R
-L12			140	2.7	LLSCN42	LLP14	LLCL14	LLCS108	HGMPT118	HKY30R	

* Clamp Torque (N • m) : LLC5108-3.3

DCMN External turning • Facing **DOUBLE CLAMP type**

Finish	Light	Medium
FF	LF	MF
(F2)	(F2)	(F2)
Medium	Medium	Medium
Standard	Standard	Standard
BP	BP	BP
(F2)	(F2)	(F2)
Stainless	Stainless	Stainless
CBN	CBN	CBN
(F2)	(F2)	(F2)

Order Number	Stock	Insert Number	Dimension (mm)	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench		
H63TH-DCMNN-H12	●	CNNC CNGC NPN/CN/A	1204-□□	100	1.7	LLSCN42	LLP14	DCX2613	DCS1	DC0621T	TKY20F
-L12			140	2.7	LLSCN42	LLP14	DCX2613	DCS1	DC0621T	TKY20F	

* Clamp Torque (N • m) : DC0621T-4.5

Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P Mild Steel	≤180HB	Finish Cutting	FY	NC3035	260~370
		Light Cutting	BY	NC3035	230~330
		Medium Cutting	MS	UE8110	260~440
Carbon Steel Alloy Steel	180HB~350HB	Finish Cutting	FN	NC3035	200~280
		Light Cutting	SH	UE8110	210~300
		Medium Cutting	MP	UE8110	190~325
M Stainless Steel	≤200HB	Finish Cutting	FN	US735	100~200
		Light Cutting	SH	US735	90~165
		Medium Cutting	MS	US735	85~165
K Gray Cast Iron	Tensile Strength 550MPa	Light Cutting	MA	UC3115	160~295
		Medium Cutting	Standard	UC3115	160~295
		Rough Cutting	Flat Top	UC3115	155~280

PCMN type inserts > A66~A870
DCMN type inserts > A66~A870
CBN & PCD inserts > B922~B924, B952

S-PARTS > P801
TECHNICAL DATA > D001

PAGE REFERENCE
-SPARE PARTS
-TECHNICAL DATA
indicates reference pages, including the above, on the right hand page of each double-page spread.

RECOMMENDED CUTTING CONDITIONS
for each work material classification, indicates recommended cutting conditions according to the ISO categories for cutting grades, P, M, and K.

● To Order : Please specify

① order number and hand of tool (right/left).

HSK-T TOOLS

OVERVIEW OF HSK-T TOOLS..... H002
 CLASSIFICATION OF HSK-T TOOLS H004
 HSK-T TOOL STANDARDS

EXTERNAL TURNING • FACING

CN[○]○[○] INSERTS TOOL HOLDERS H006
 DN[○]○[○] INSERTS TOOL HOLDERS H011

EXTERNAL TURNING • FACING • BORING

CN[○]○[○] INSERTS TOOL HOLDERS H008

EXTERNAL TURNING • COPYING

DN[○]○[○] INSERTS TOOL HOLDERS H009

EXTERNAL TURNING • FACING • COPYING

RC[○]○[○] INSERTS TOOL HOLDERS H012

FACING • COPYING

VB[○]○[○] INSERTS TOOL HOLDERS H013

GROOVING

MG INSERTS TOOL HOLDERS H014

THREADING

MMT INSERTS TOOL HOLDERS H016

MT INSERTS TOOL HOLDERS H017

EXTERNAL TURNING TOOL HOLDERS... H019

BORING BAR HOLDERS..... H021

BORING BAR SLEEVES..... H022

*Arranged by Alphabetical order

H022 H100TH-B[○]○[○]○[○]
 H020 H100TH-EN3232R/L-130
 H019 H100TH-EV3232R/L-180
 H008 H63TH-A[○]○[○]○[○]DCLNR/L12
 H021 H63TH-B[○]○[○]○[○]
 H008 H63TH-DCLNL-L12-3
 H006 H63TH-DCLNR/L-DX12
 H007 H63TH-DCMNN-H/L12
 H011 H63TH-DDJNL-L15-3
 H009 H63TH-DDJNR/L-DX15
 H010 H63TH-DDNNN-H/L15
 H020 H63TH-EN2525R/L-115
 H021 H63TH-EV2020R/L-105-3
 H019 H63TH-EV2525R/L-112

H014 H63TH-MGHR/L-DX43[○]○[○]
 H016 H63TH-MMTENR-H/L16
 H016 H63TH-MMTER-DX16
 H017 H63TH-MTHR/L-DX43
 H006 H63TH-PCLNR/L-DX12
 H007 H63TH-PCMNN-H/L12
 H009 H63TH-PDJNR/L-DX15
 H010 H63TH-PDNNN-H/L15
 H012 H63TH-PRDCN-H/L12
 H012 H63TH-PRGCR/L-DX12
 H013 H63TH-SVPBR/L-DX16
 H013 H63TH-SVVBN-H/L16
 H022 SL32[○]○[○]-90

Tooling system
for turning on
multi-task machines

HSK-T TOOLS

HSK-T System (ICTM standard)

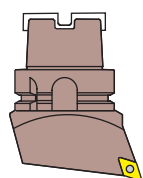
HSK-T is a new HSK system designed for turning on multi-task machines that are compatible with HSK-A type (ISO standard: ISO12164-1:2001). It was jointly developed by a consortium of Japanese manufacturers and is now used worldwide as the ICTM standard. The HSK-T type was registered in the ISO standard in 2008. (ISO12164-3:2008)



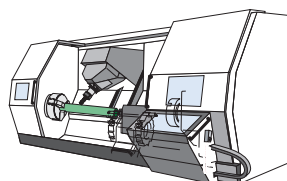
High accuracy cutting edge positioning

The HSK-T type has a closer tolerance between the spindle key and tool holder keyway than the HSK-A type. This results in higher cutting edge positional accuracies. For milling, the conventional HSK-A type tools can be still used.

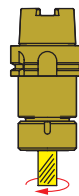
Compatible with both multi-task machines and machining centres



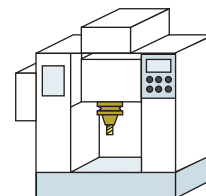
HSK-T (ISO standard)
Turning tool holder



HSK-T spindle
Multi-task machines



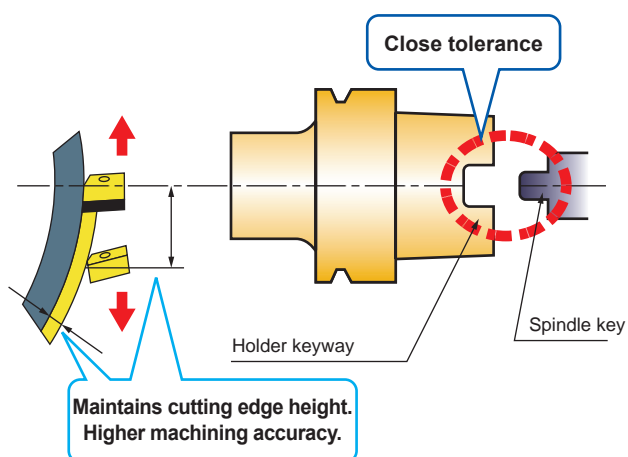
HSK-A63 (ISO standard)
Rotating tool holder



HSK-A spindle
Machining centre

HSK-T TOOLS

Improved keyway tolerance



Tolerance comparison (Example) (mm)

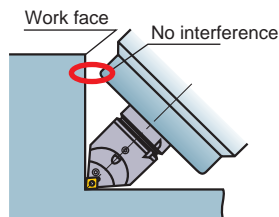
System	Key Tolerance (mm)	Minimum Clearance (mm)	Maximum Clearance (mm)
HSK A63	0.10	0.15	0.33
HSK T63	0.025	0.015	0.075

High accuracy and rigidity HSK-T type tooling system developed for use on multi-task machines.

Straight type tools suitable for use on multi-task machines

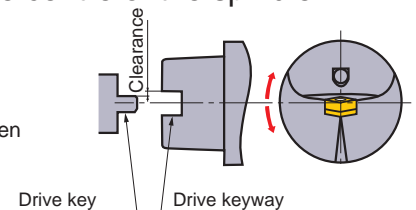
Avoid workpiece interference with improved tool accessibility.

By tilting the machines B spindle (main axis of the tool) at 45 deg, interference between the spindle, holder, workpiece and chuck can be avoided.



Improve centreline height by positioning the cutting edge at the centre of the spindle.

Increased stability and accuracy can be achieved because the cutting edge centreline height is not affected by the gap between the spindle and the key.



New one-action type double clamp series

The double clamp mechanism offers high rigidity, accuracy and reliability that ensures secure insert clamping. There fore making it suitable turning of difficult to machine materials such as stainless and heat resistant alloys.



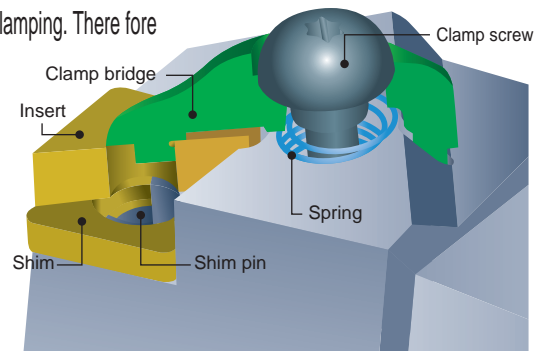
Handed type for turning and facing



Straight type for turning and facing



For turning, facing and boring



HSK-T TOOLS

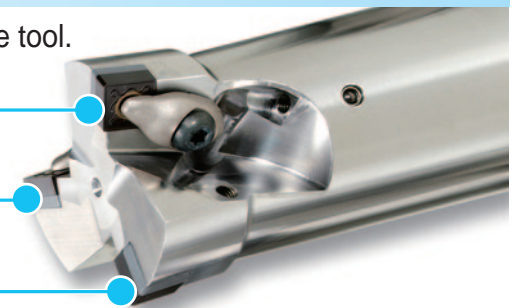
3 on 1 tool for process and tool consolidation

3 turning inserts of the same geometry can be installed on a single tool.

The same type of inserts can be installed for quick change with spare tools.

Different types of inserts can be installed for different applications (roughing, semi finishing and finishing)

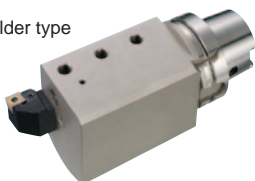
Inserts in different grade types can be installed to cover various kinds of workpieces.



New HSK-T100 size for large workpieces

Larger tool holder sizes for high efficiency machining.

Square shank holder type



Boring bar / Drill type

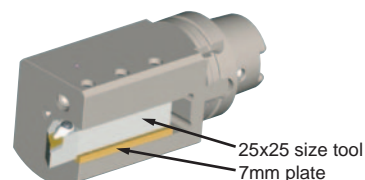


Sleeve




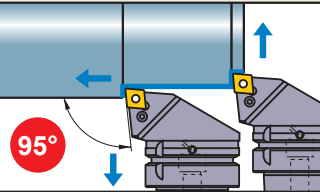

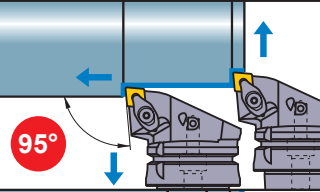

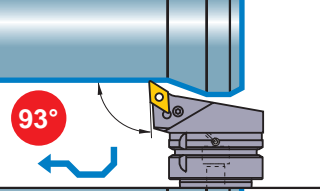

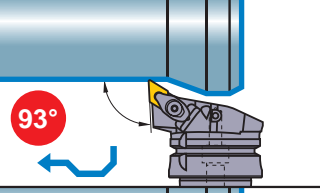

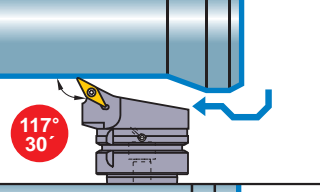

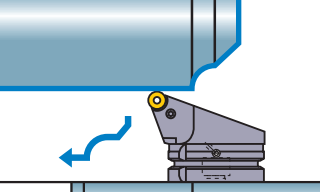

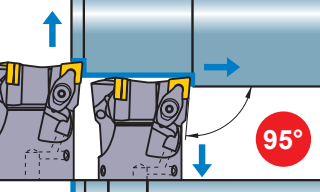

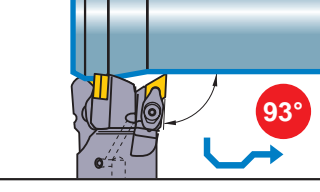
A single tool can be used with different sized tool holders.


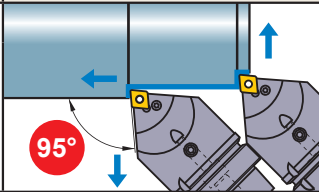

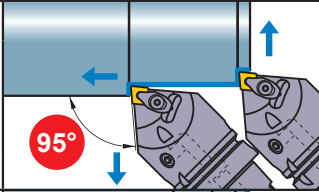

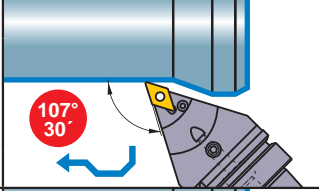

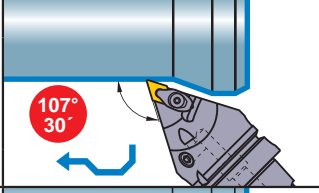

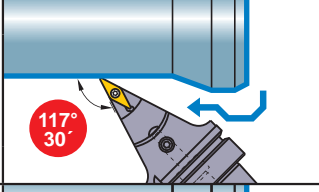

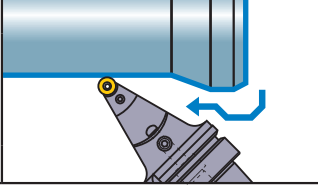
- Available for use with JIS B4126 (ISO 5610) 32x32 and 32x25 tools.
- Possible to fit a 25x25 tool by using a 7mm plate.
- *Please prepare a plate on your own.




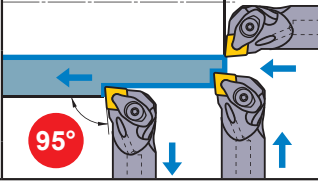
CLASSIFICATION OF HSK-T TOOLS

EXTERNAL TURNING • FACING • COPYING


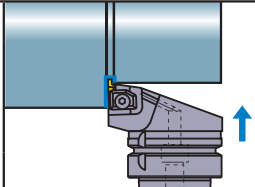

Order Number	Cutting Mode
H63TH-PCLNR/L-DX12  H006	
H63TH-DCLNR/L-DX12  H006	
H63TH-PDJNR/L-DX15  H009	
H63TH-DDJNR/L-DX15  H009	
H63TH-SVPBR/L-DX16  H013	
H63TH-PRGCR/L-DX12  H012	
H63TH-DCLNL-L12-3  H008	
H63TH-DDJNL-L15-3  H011	

Order Number	Cutting Mode
H63TH-PCMNN-H/L12  H007	
H63TH-DCMNN-H/L12  H007	
H63TH-PDNNN-H/L15  H010	
H63TH-DDNNN-H/L15  H010	
H63TH-SVVBH-H/L16  H013	
H63TH-PRDCN-H/L12  H012	


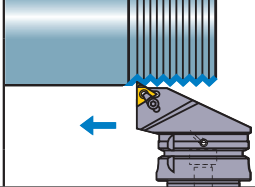


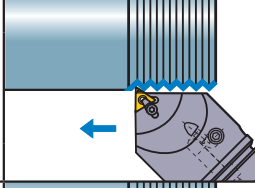


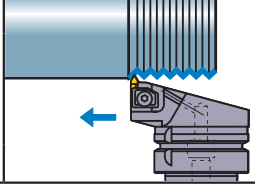

EXTERNAL TURNING • FACING • BORING

Order Number	Cutting Mode
H63TH-A25KDCLNR/L12 H63TH-A32LDCLNR/L12  H008	


GROOVING

Order Number	Cutting Mode
H63TH-MGHR/L-DX43   	






THREADING

Order Number	Cutting Mode
H63TH-MMTER-DX16   	
H63TH-MMTENR-H/L16   	
H63TH-MTHR/L-DX43   	

EXTERNAL TURNING TOOL HOLDERS

Order Number	Holder
H63TH-EV2525R/L-112  	
H100TH-EV3232R/L-180  	
H63TH-EN2525R/L-115  *1 	
H100TH-EN3232R/L-130  *1 	
H63TH-EV2020R/L-105-3  	

BORING BAR HOLDERS

Order Number	Holder
H63TH-B  	
H100TH-B  	
SL32-90 (Sleeve)  *2 	

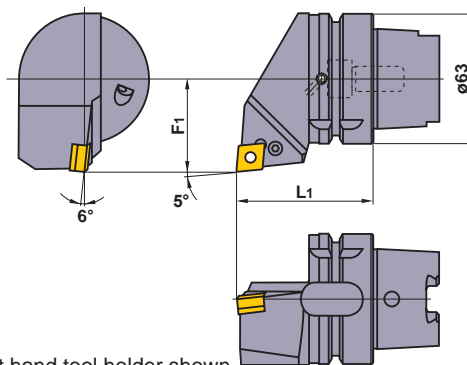
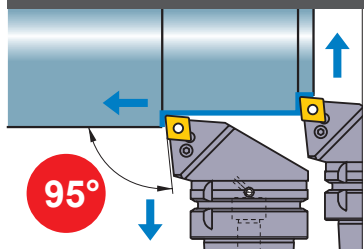
*1 Mitsubishi Materials is licensed for production and distribution of these tools from MORI SEIKI CO., LTD under Patent No.3720202.

*2 The SL32-90 sleeve is only for use with H100TH-B32-135.









FOR MULTI-TASK MACHINES






PCLN

External turning • Facing



Right hand tool holder shown.

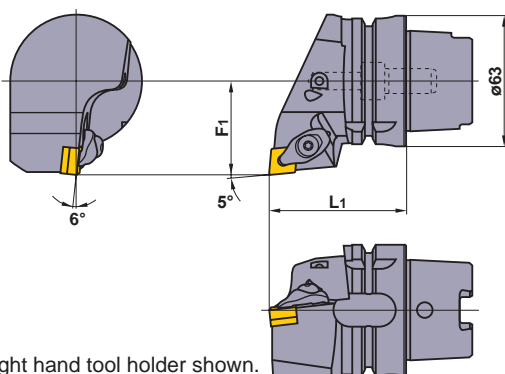
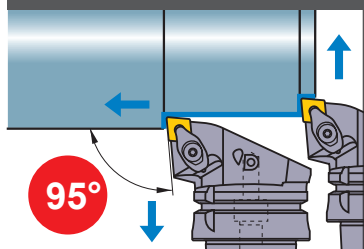
Finish	Light	Medium
FH  (12)	LP  (12)	MP  (12)
Medium MH  (12)	Medium Standard  (12)	Medium-Rough RP  (12)
Stainless MM  (12)	CBN  (12)	

Order Number	Stock		Insert Number	Dimensions (mm)		Tool Weight (kg)					
	R	L		L1	F1		Shim	Shim Pin	Clamp Lever	Clamp Screw	Wrench
H63TH-PCLNR/L-DX12	●	●	CNM CNG NP-CNA	1204	65 45	1.3	LLSCN42	LLP14	LLCL14	LLCS108	HKY30R









* Clamp Torque (N • m) : LLCS108=3.3







DCLN

External turning • **DOUBLE CLAMP type** Facing



Right hand tool holder shown.

Finish	Light	Medium
FH  (12)	LP  (12)	MP  (12)
Medium MH  (12)	Medium Standard  (12)	Medium-Rough RP  (12)
Stainless MM  (12)	CBN  (12)	

Order Number	Stock		Insert Number	Dimensions (mm)		Tool Weight (kg)						
	R	L		L1	F1		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
H63TH-DCLNR/L-DX12	●	●	CNM CNG NP-CNA	1204	65 45	1.3	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

* Clamp Torque (N • m) : DC0621T=5.0

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260-370
			Light Cutting	SY	NX3035	235-335
			Medium Cutting	MS	UE6110	260-440
	Carbon Steel Alloy Steel	180HB-350HB	Finish Cutting	FH	NX3035	200-280
			Light Cutting	SH	UE6110	210-355
			Medium Cutting	MP	UE6110	190-325
M	Stainless Steel	≤200HB	Finish Cutting	FH	US735	105-200
			Light Cutting	SH	US735	95-185
			Medium Cutting	MS	US735	85-165
K	Gray Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160-295
			Medium Cutting	Standard	UC5115	160-295
			Rough Cutting	Flat Top	UC5115	155-280

● : Inventory maintained in Japan.

PCLN type inserts > A066-A070
 DCLN type inserts > A066-A070
 CBN & PCD inserts > B022-B024, B052

PCMN				External turning • Facing				Finish	Light	Medium	
								(12)	(12)	(12)	
								Medium	Medium	Medium – Rough	
								(12)	(12)	(12)	
								Stainless	CBN		
								(12)	(12)		
Order Number	Stock	Insert Number	Dimensions (mm)	Tool Weight (kg)							
			L1		Shim	Shim Pin	Clamp Lever	Clamp Screw	Plug	Wrench	
H63TH-PCMNN-H12	●		1204	100	1.7	LLSCN42	LLP14	LLCL14	LLCS108	HGM-PT1/8	HKY30R
-L12	●			140	2.7	LLSCN42	LLP14	LLCL14	LLCS108	HGM-PT1/8	HKY30R

* Clamp Torque (N • m) : LLCS108=3.3

DCMN				External turning • DOUBLE CLAMP type Facing				Finish	Light	Medium	
								(12)	(12)	(12)	
								Medium	Medium	Medium – Rough	
								(12)	(12)	(12)	
								Stainless	CBN		
								(12)	(12)		
Order Number	Stock	Insert Number	Dimensions (mm)	Tool Weight (kg)							
			L1		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	
H63TH-DCMNN-H12	●		1204	100	1.7	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
-L12	●			140	2.7	LLSCN42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

* Clamp Torque (N • m) : DC0621T=5.0

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260–370
			Light Cutting	SY	NX3035	235–335
			Medium Cutting	MS	UE6110	260–440
	Carbon Steel Alloy Steel	180HB–350HB	Finish Cutting	FH	NX3035	200–280
			Light Cutting	SH	UE6110	210–355
			Medium Cutting	MP	UE6110	190–325
M	Stainless Steel	≤200HB	Finish Cutting	FH	US735	105–200
			Light Cutting	SH	US735	95–185
			Medium Cutting	MS	US735	85–165
K	Gray Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160–295
			Medium Cutting	Standard	UC5115	160–295
			Rough Cutting	Flat Top	UC5115	155–280

PCMN type inserts > A066–A070

DCMN type inserts > A066–A070

CBN & PCD inserts > B022–B024, B052

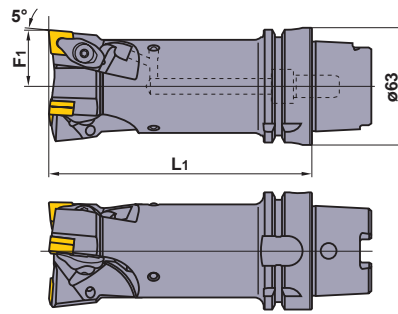
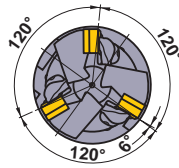
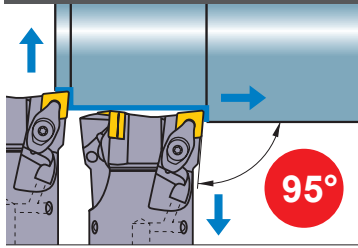
SPARE PARTS > P001

TECHNICAL DATA > Q001









FOR MULTI-TASK MACHINES

DCLN

External turning • Facing **DOUBLE CLAMP type**



Left hand tool holder only.

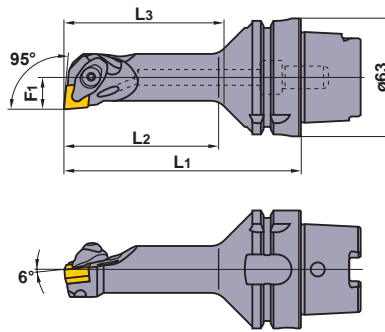
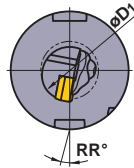
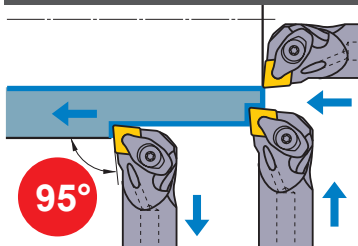
Finish	Light	Medium
FH  (12)	LP  (12)	MP  (12)
Medium MH  (12)	Medium Standard  (12)	Medium-Rough RP  (12)
Stainless MM  (12)	CBN  (12)	

Order Number	Stock		Insert Number	Dimensions (mm)		Tool Weight (kg)	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw *	Wrench
	L			L1	F1							
H63TH-DCLNL-L12-3	●		CNM CNG NP-CNA	1204	140 30	2.2	LLSCP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F









* Clamp Torque (N • m) : DC0621T=5.0

DCLN

External turning • Facing • Boring **DOUBLE CLAMP type**



Right hand tool holder shown.

Finish	Light	Medium
FH  (12)	LP  (12)	MP  (12)
Medium MH  (12)	Medium Standard  (12)	Medium-Rough RP  (12)
Stainless MM  (12)	CBN  (12)	

Order Number	Stock		Insert Number	Dimensions (mm)					Min. Cutting Diameter D1 (mm)	Tool Weight (kg)	Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw *	Wrench	
	R	L		L1	L2	L3	F1	RR°									
H63TH-A25KDCLNR/L12	●	●	CNM CNG NP-CNA	1204	125	82	84	17	11	32	1.1	LLSCP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F
-A32LDCLNR/L12	●	●	NP-CNA	1204	140	100	102	22	13	40	1.4	LLSCP42	LLP14	DCK2613	DCS1	DC0621T	TKY20F

* Clamp Torque (N • m) : DC0621T=5.0

RECOMMENDED CUTTING CONDITIONS

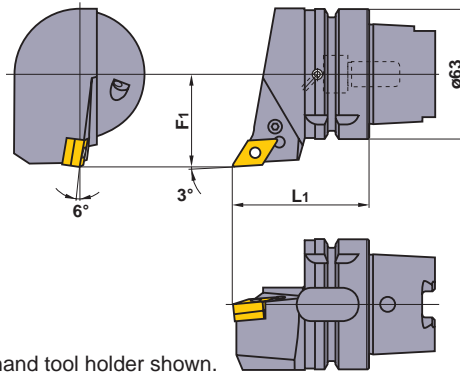
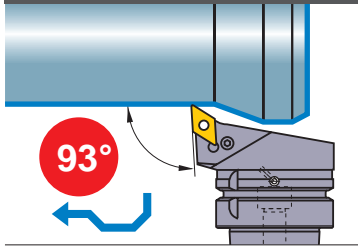
	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260-370
			Light Cutting	SY	NX3035	235-335
			Medium Cutting	MS	UE6110	260-440
	Carbon Steel Alloy Steel	180HB-350HB	Finish Cutting	FH	NX3035	200-280
			Light Cutting	SH	UE6110	210-355
			Medium Cutting	MP	UE6110	190-325
M	Stainless Steel	≤200HB	Finish Cutting	FH	US735	105-200
			Light Cutting	SH	US735	95-185
			Medium Cutting	MS	US735	85-165
K	Gray Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160-295
			Medium Cutting	Standard	UC5115	160-295
			Rough Cutting	Flat Top	UC5115	155-280

● : Inventory maintained in Japan.









DCLN type inserts > A066-A070
CBN & PCD inserts > B022-B024, B052

PDJN

External turning • Copying



Right hand tool holder shown.

Finish	Light	Medium
FH  (15)	LP  (15)	MP  (15)
Medium MH  (15)	Medium-Rough RP  (15)	Stainless MM  (15)
G Class R/L  (15)	CBN  (15)	

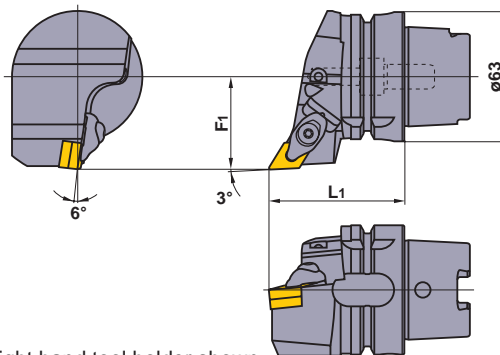
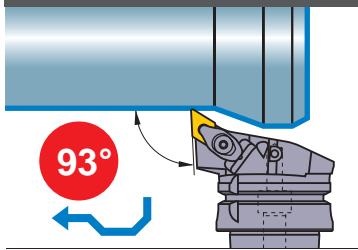
Order Number	Stock		Insert Number	Dimensions (mm)		Tool Weight (kg)	*2				
	R	L		L1	F1		Shim	Shim Pin	Clamp Lever	Clamp Screw	Wrench
H63TH-PDJNR/L-DX15	●	●	DNM DNG NP-DN	1504	65 45	1.2	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HKY30R

*1 Clamp Torque (N • m) : LLCS108=3.3









*2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.

DDJN

External turning • DOUBLE CLAMP type Copying



Right hand tool holder shown.

Finish	Light	Medium
FH  (15)	LP  (15)	MP  (15)
Medium MH  (15)	Medium-Rough RP  (15)	Stainless MM  (15)
G Class R/L  (15)	CBN  (15)	

Order Number	Stock		Insert Number	Dimensions (mm)		Tool Weight (kg)	*2					
	R	L		L1	F1		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
H63TH-DDJNR/L-DX15	●	●	DNM DNG NP-DN	1504	65 45	1.2	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F

*1 Clamp Torque (N • m) : DC0621T=5.0

*2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260-370
			Light Cutting	SY	NX3035	235-335
			Medium Cutting	MS	UE6110	260-440
	Carbon Steel Alloy Steel	180HB-350HB	Finish Cutting	FH	NX3035	200-280
			Light Cutting	SH	UE6110	210-355
			Medium Cutting	MP	UE6110	190-325
M	Stainless Steel	≤200HB	Finish Cutting	FH	US735	105-200
			Light Cutting	SH	US735	95-185
			Medium Cutting	MS	US735	85-165
K	Gray Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160-295
			Medium Cutting	Standard	UC5115	160-295
			Rough Cutting	Flat Top	UC5115	155-280

CBN & PCD inserts > B025, B026, B052

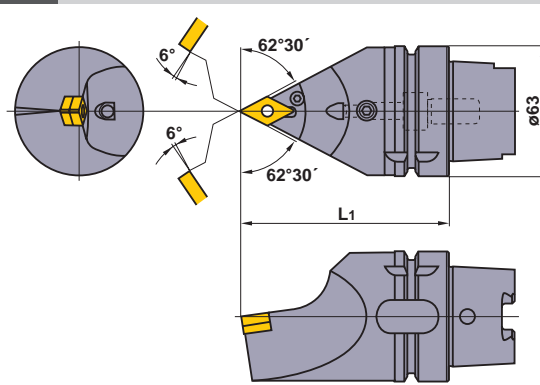
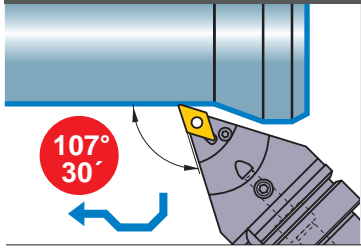
PDJN type inserts > A071-A075
DDJN type inserts > A071-A075









SPARE PARTS > P001
TECHNICAL DATA > Q001

FOR MULTI-TASK MACHINES

PDNN

External turning • Copying



Finish	Light	Medium
FH  (15)	LP  (15)	MP  (15)
Medium MH  (15)	Medium – Rough RP  (15)	Stainless MM  (15)
G Class R/L  (15)	CBN  (15)	

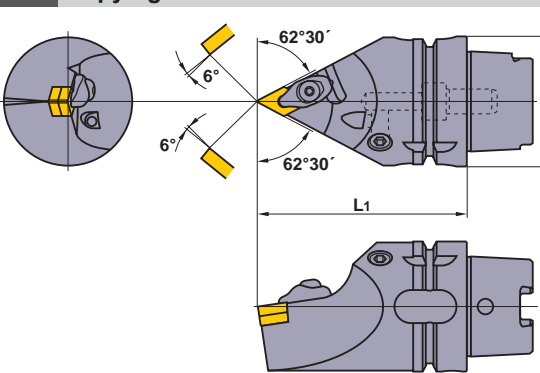
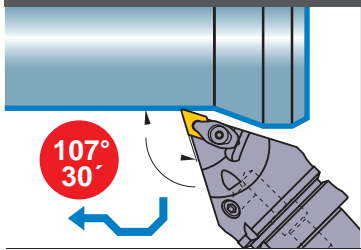
Order Number	Stock	Insert Number	Dimensions (mm)	Tool Weight (kg)	*2						
					Shim	Shim Pin	Clamp Lever	Clamp Screw	Plug	Wrench	
H63TH-PDNNN-H15	●	DNM DNG NP-DNA	1504	100	1.6	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HGM-PT1/8	HKY30R
-L15	●			140	2.5	LLSDN43 (LLSDN42)	LLP14	LLCL24	LLCS108	HGM-PT1/8	HKY30R









*1 Clamp Torque (N • m) : LLCS108=3.3

*2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.

DDNN

External turning • DOUBLE CLAMP type Copying



Finish	Light	Medium
FH  (15)	LP  (15)	MP  (15)
Medium MH  (15)	Medium – Rough RP  (15)	Stainless MM  (15)
G Class R/L  (15)	CBN  (15)	

Order Number	Stock	Insert Number	Dimensions (mm)	Tool Weight (kg)	*2						
					Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench	
H63TH-DDNNN-H15	●	DNM DNG NP-DNA	1504	100	1.6	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F
-L15	●			140	2.5	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F

*1 Clamp Torque (N • m) : DC0621T=5.0

*2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260–370
			Light Cutting	SY	NX3035	235–335
			Medium Cutting	MS	UE6110	260–440
	Carbon Steel Alloy Steel	180HB–350HB	Finish Cutting	FH	NX3035	200–280
			Light Cutting	SH	UE6110	210–355
			Medium Cutting	MP	UE6110	190–325
M	Stainless Steel	≤200HB	Finish Cutting	FH	US735	105–200
			Light Cutting	SH	US735	95–185
			Medium Cutting	MS	US735	85–165
K	Gray Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160–295
			Medium Cutting	Standard	UC5115	160–295
			Rough Cutting	Flat Top	UC5115	155–280

● : Inventory maintained in Japan.







CBN & PCD inserts > B025, B026, B052

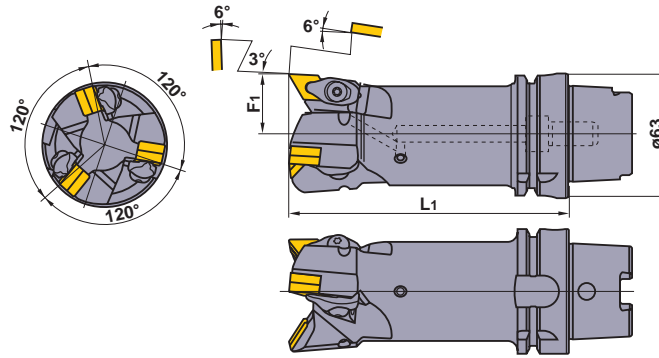
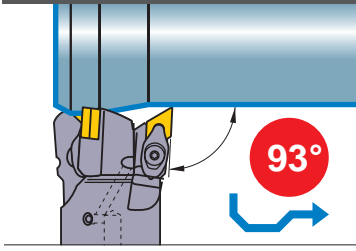
PDNN type inserts > A071–A075
DDNN type inserts > A071–A075

DDJN

External turning • Facing

DOUBLE CLAMP type

Finish	Light
FH  (15)	LP  (15)
Medium	Medium
MP  (15)	MH  (15)
Medium-Rough	Stainless
RP  (15)	MM  (15)



Left hand tool holder only.

Order Number	Stock	Insert Number	Dimensions (mm)		Tool Weight (kg)	*2					
			L1	F1		Shim	Shim Pin	Clamp Bridge	Spring	Clamp Screw	Wrench
H63TH-DDJNL-L15-3	●	DNM DNG NP-DN	1504	140 30	2.2	LLSDN43 (LLSDN42)	LLP24	DCK2613	DCS1	DC0621T	TKY20F

*1 Clamp Torque (N • m) : DC0621T=5.0

*2 Please use shim no. LLSDN42 with 6.35mm thick inserts. When using 6.35mm thick inserts, the shim should be ordered separately.

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Finish Cutting	FY	NX3035	260–370
			Light Cutting	SY	NX3035	235–335
			Medium Cutting	MS	UE6110	260–440
	Carbon Steel Alloy Steel	180HB–350HB	Finish Cutting	FH	NX3035	200–280
			Light Cutting	SH	UE6110	210–355
			Medium Cutting	MP	UE6110	190–325
M	Stainless Steel	≤200HB	Finish Cutting	FH	US735	105–200
			Light Cutting	SH	US735	95–185
			Medium Cutting	MS	US735	85–165
K	Gray Cast Iron	Tensile Strength ≤350MPa	Light Cutting	MA	UC5115	160–295
			Medium Cutting	Standard	UC5115	160–295
			Rough Cutting	Flat Top	UC5115	155–280

DDNN type inserts > A071–A075
 CBN & PCD inserts > B025, B026, B052

SPARE PARTS > P001
 TECHNICAL DATA > Q001

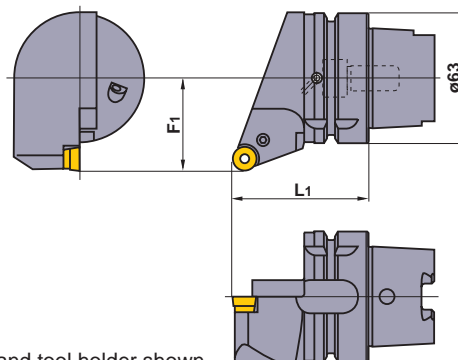
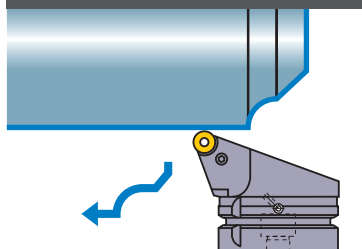
H011

FOR MULTI-TASK MACHINES

PRGC

External turning • Facing • Copying

Medium



Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)		Tool Weight (kg)					
	R	L		L1	F1		Shim	Shim Pin	Clamp Lever	Clamp Screw	Wrench
H63TH-PRGCR/L-DX12	●	●	RCMX 1204M0	65	45	1.2	LLSRN123	LLP13	LLCL112	LLCS106	HKY25R

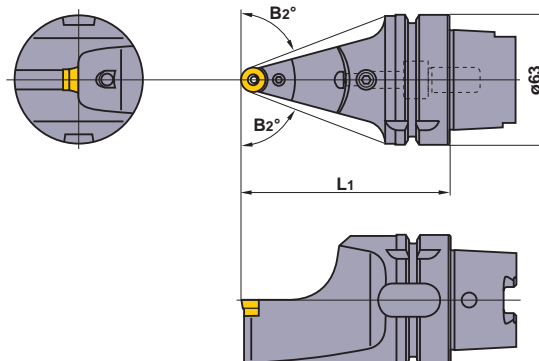
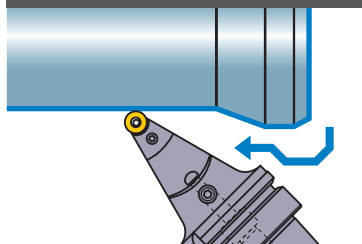
* Clamp Torque (N • m) : LLCS106=2.2

HSK-T TOOLS

PRDC

External turning • Facing • Copying

Medium



Order Number	Stock		Insert Number	Dimensions (mm)		Tool Weight (kg)						
	L1	B2°		Shim	Shim Pin		Clamp Lever	Clamp Screw	Plug	Wrench		
H63TH-PRDCN-H12	●	●	RCMX 1204M0	100	69	1.4	LLSRN123	LLP13	LLCL112	LLCS106	HGM-PT1/8	HKY25R
-L12	●	●		140	75	2.3	LLSRN123	LLP13	LLCL112	LLCS106	HGM-PT1/8	HKY25R

* Clamp Torque (N • m) : LLCS106=2.2

RECOMMENDED CUTTING CONDITIONS

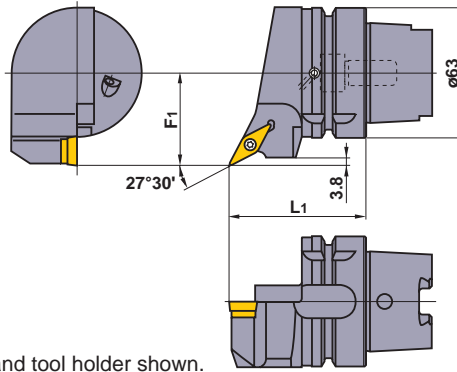
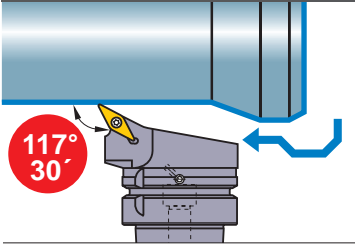
	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Medium Cutting	Standard	UE6110	205—350
	Carbon Steel • Alloy Steel	180HB—350HB	Medium Cutting	Standard	UE6110	150—260
M	Stainless Steel	≤200HB	Medium Cutting	Standard	US735	70—130

● : Inventory maintained in Japan.

PRGC type inserts > A109
PRDC type inserts > A109

SVPB

Facing • Copying



Right hand tool holder shown.

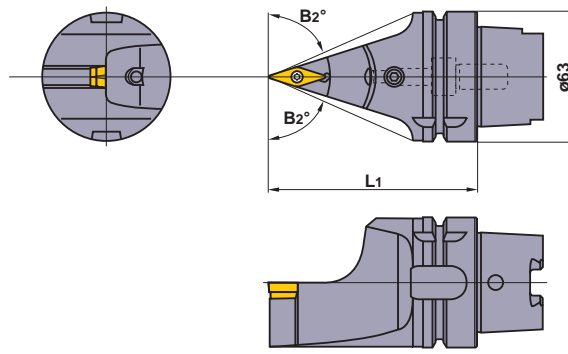
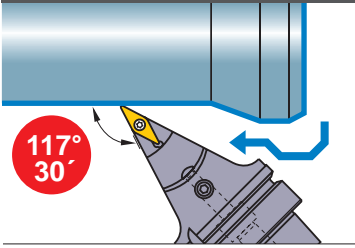
Finish	Light
R/L-F (16)	SV (16)
Medium MV (16)	Medium MP (16)
CBN (16)	

Order Number	Stock		Insert Number	Dimensions (mm)		Tool Weight (kg)	Shim	Shim Pin	Clamp Screw	Wrench
	R	L		L1	F1					
H63TH-SVPBR/L-DX16	●	●	VBMT VBGT	1604	65 45	1.1	SPSVN32	BCP141	TS35D	TKY15F

* Clamp Torque (N • m) : TS35D=3.5

SVVB

Facing • Copying



Finish	Light
R/L-F (16)	SV (16)
Medium MV (16)	Medium MP (16)
CBN (16)	

Order Number	Stock		Insert Number	Dimensions (mm)		Tool Weight (kg)	Shim	Shim Pin	Clamp Screw	Plug	Wrench
	L	R		L1	B2°						
H63TH-SVVBH-H16	●	●	VBMT VBGT	1604	100 66°30'	1.3	SPSVN32	BCP141	TS35D	HGM-PT1/8	TKY15F
-L16	●	●	VBMT VBGT	1604	140 72°30'	2.2	SPSVN32	BCP141	TS35D	HGM-PT1/8	TKY15F

* Clamp Torque (N • m) : TS35D=3.5

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Cutting Mode	Breaker	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	Finish Cutting	F	AP25N	250 (150–300)
			Medium Cutting	MV	UE6020	200 (150–250)
	Carbon Steel Alloy Steel	180HB–350HB	Finish Cutting	F	AP25N	210 (150–260)
			Medium Cutting	MV	UE6020	170 (120–210)
M	Stainless Steel	≤200HB	Medium Cutting	MV	US735	100 (70–120)
K	Gray Cast Iron	Tensile Strength≤350MPa	Medium Cutting	MV	UE6020	170 (140–200)

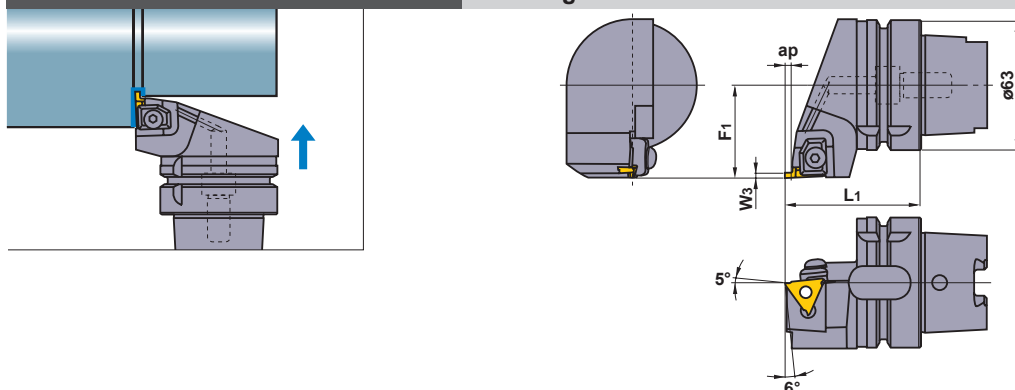
- SVPB type inserts > A119, A120
- SVVB type inserts > A119, A120
- CBN inserts > B045

- SPARE PARTS > P001
- TECHNICAL DATA > Q001

FOR MULTI-TASK MACHINES

MG

Grooving



Right hand tool holder shown.

Order Number	Stock		Insert Number	Groove Width W ₃ (mm)	Max. Groove Depth ap (mm)	Dimensions (mm)		Tool Weight (kg)	Clamp Bridge	Clamp Screw	Spring	Wrench	
	R	L				L1	F1						
H63TH-MGHR/L-DX4315	●	●	MGTR/L 43125 I 43470	1.25	1.2								
				1.45	1.5								
				1.5 ≤ W ₃ ≤ 2.3	3	65	45	1.2	MTK1R/L	HBH06020	MES3	HKY40R	
				2.3 < W ₃ ≤ 3.3	4.5								
-DX4323	●	●		3.3 < W ₃ ≤ 4.7	4.5								
-DX4333	●	●											

* Clamp Torque (N · m) : HBH06020=7.0

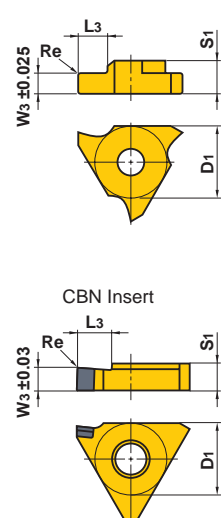
HSK-T TOOLS

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)
P	Carbon Steel Alloy Steel	180–350HB	VP20MF	120 (100–140)	0.10 (0.03–0.18)
			NX2525	130 (100–160)	0.12 (0.03–0.2)
M	Stainless Steel	≤200HB	VP20MF	120 (100–140)	0.10 (0.03–0.18)
K	Gray Cast Iron	Tensile Strength ≤ 350MPa	VP20MF	120 (100–140)	0.10 (0.03–0.18)

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
(10 inserts in one case) (CBN inserts are available in 1 piece in one case.)

INSERTS FOR MG TYPE

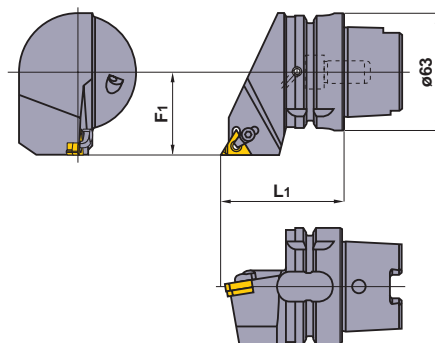
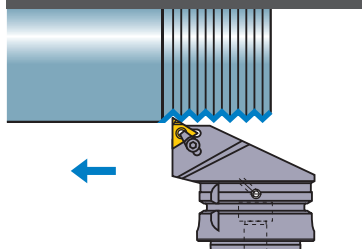
Order Number	Stock								Groove Width W ₃ (mm)	Dimensions (mm)				Geometry
	Coated		Cermet		Carbide		CBN			L ₃	D ₁	S ₁	Re	
	VP20MF		NX2525		UTi20T		MB8025							
	R	L	R	L	R	L	R	L						
MGTR/L43125	●	●	●	□	●	●	●	●	1.25	1.2	12.7	4.76	0.2	MGTR/L... 
43145	●	□	□	□	●	□	●	□	1.45	1.5	12.7	4.76	0.2	
43150	●	●	●	●	●	●	●	●	1.5	3	12.7	4.76	0.2	
43175	●	●	●	□	●	●	●	●	1.75	3	12.7	4.76	0.2	
43200	●	●	●	●	●	●	●	●	2	3	12.7	4.76	0.2	
43230	●	●	●	●	●	●	●	●	2.3	3	12.7	4.76	0.2	
43250	●	●	●	●	●	●	●	●	2.5	4.5	12.7	4.76	0.3	
43260	●	□	□	□	●	●	●	●	2.6	4.5	12.7	4.76	0.3	
43270	●	□	□	□	●	□	●	□	2.7	4.5	12.7	4.76	0.3	
43280	□	●	□	□	●	●	●	●	2.8	4.5	12.7	4.76	0.3	
43300	●	●	●	●	●	●	●	●	3	4.5	12.7	4.76	0.3	
43320	●	□	□	□	●	●	●	●	3.2	4.5	12.7	4.76	0.3	
43330	□	●	□	□	●	●	●	●	3.3	4.5	12.7	4.76	0.3	
43350	●	□	●	□	●	●	●	●	3.5	4.5	12.7	4.76	0.3	
43400	●	●	●	□	●	●	●	●	4	4.5	12.7	4.76	0.3	
43420	●	□	□	□	●	□	●	□	4.2	4.5	12.7	4.76	0.4	
43430	●	□	□	□	●	●	●	●	4.3	4.5	12.7	4.76	0.4	
43450	●	●	●	●	●	●	●	●	4.5	4.5	12.7	4.76	0.4	
43470	●	□	□	□	●	□	●	□	4.7	4.5	12.7	4.76	0.4	

Right hand insert shown.

FOR MULTI-TASK MACHINES

MMTE

Threading



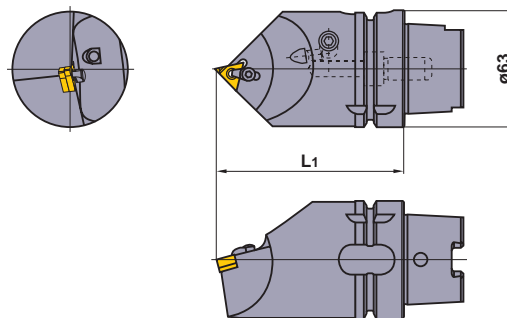
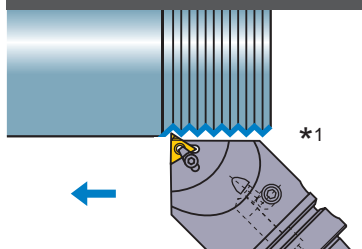
Right hand tool holder only.

Order Number	Stock	Insert Number	Dimensions (mm)		Tool Weight (kg)	Clamp Bridge	Clamp Screw *	Stop Ring	Shim	Shim Screw *	Wrench
			L1	F1							
H63TH-MMTER-DX16	●	MMT16ER	65	45	1.2	SETK51	SETS51	CR4	CTE32TP15	HFC03008	①TKY15F ②HKY20R

* Clamp Torque (N · m) : SETS51=3.5, HFC03008=1.5

MMTEN

Threading



Tool holder for right hand insert only.

Order Number	Stock	Insert Number	Dimensions (mm)		Tool Weight (kg)	Clamp Bridge	Clamp Screw *2	Stop Ring	Shim	Shim Screw *2	Plug	Wrench
			L1									
H63TH-MMTENR-H16	●	MMT16ER	100		1.7	SETK51	SETS51	CR4	CTE32TP15	HFC03008	HGM-PT1/8	①TKY15F ②HKY20R
-L16	●		140		2.7	SETK51	SETS51	CR4	CTE32TP15	HFC03008	HGM-PT1/8	①TKY15F ②HKY20R

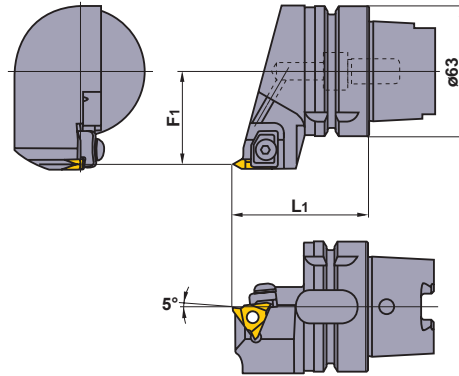
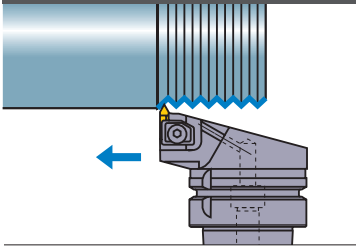
*1 For use with B axis tilted at 45 degrees.

*2 Clamp Torque (N · m) : SETS51=3.5, HFC03008=1.5

RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	≤180HB	VP10MF	150 (70—230)
			VP15TF	100 (60—140)
	Carbon Steel Alloy Steel	180—350HB	VP10MF	140 (80—200)
			VP15TF	100 (60—140)
M	Stainless Steel	≤200HB	VP10MF	130 (80—180)
K	Gray Cast Iron	Tensile Strength≤350MPa	VP15TF	80 (40—120)
			VP10MF	140 (80—200)
			VP15TF	90 (60—120)

● : Inventory maintained in Japan.
(5 inserts in one case)

MT**Threading**

Right hand tool holder shown.

Order Number	Stock		Insert Number	Dimensions (mm)		Tool Weight (kg)		*		
	R	L		L1	F1		Clamp Bridge	Clamp Screw	Spring	Wrench
H63TH-MTHR/L-DX43	●	●	MTTR/L 43○○○○	65	45	1.2	MTK1R/L	HBH06020	MES3	HKY40R

* Clamp Torque (N • m) : HBH06020=7.0

RECOMMENDED CUTTING CONDITIONS

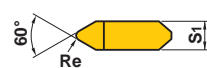



	Work Material	Hardness	Grade	Cutting Speed (m/min)
P	Mild Steel	$\leq 180\text{HB}$	UP20M	140 (100–180)
			NX55	200 (150–250)
			UTi20T	120 (100–150)
	Carbon Steel Alloy Steel	180HB–350HB	UP20M	120 (100–150)
			NX55	170 (150–200)
			UTi20T	100 (70–120)
M	Stainless Steel	$\leq 200\text{HB}$	UP20M	120 (80–150)
			UTi20T	100 (70–130)
K	Gray Cast Iron	Tensile Strength $\leq 350\text{MPa}$	UP20M	80 (60–100)
			UTi20T	80 (60–100)
			HTi10	100 (70–130)

● : Inventory maintained in Japan.
(10 inserts in one case)

APPLICABLE INSERT	> H018
SPARE PARTS	> P001
TECHNICAL DATA	> Q001

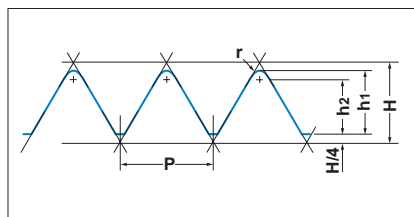
FOR MULTI-TASK MACHINES

INSERTS FOR MT TYPE

Type	Order Number	Class	Coated					ISO Pitch mm (thread/inch)	Dimensions (mm)			Geometry
			UP20M	NX2525	NX55	UT120T	HT110		D1	S1	Re	
General • 60°	MTTR436000	G		●	●	●		-0.8	12.7	4.76	0	MTTR/L(60°) (G Class)   Right hand insert shown.
	R436001	G	●	●	●	●	1.0-1.75	12.7	4.76	0.1		
	L436001	G	●			●	1.0-1.75	12.7	4.76	0.1		
	R436002	G	●	●	●	●	2.0-2.5	12.7	4.76	0.2		
	L436002	G		●	▲	●	2.0-2.5	12.7	4.76	0.2		
	R436003	G	□	●	●	●	●	3.0-3.5	12.7	4.76	0.3	
	L436003	G		●	▲	●		3.0-3.5	12.7	4.76	0.3	
	R436004	G		●	●	●		4.0-4.5	12.7	4.76	0.4	
General • 55°	MTTR435501	G		●	▲	●		(28-10)	12.7	4.76	0.1	MTTR/L(55°) (G Class)   Right hand insert shown.
	R435502	G		●	▲	●		(16-8)	12.7	4.76	0.2	
	R435503	G		●	▲	●		(11-8)	12.7	4.76	0.3	

STANDARD DEPTH OF CUT

- The chart on the right shows the cutting depths when machining external ISO metric screw threads.
- When you use cermet grades or cut stainless steel, please increase the number of passes by 2-3 times.



METRIC THREAD

Unit : mm

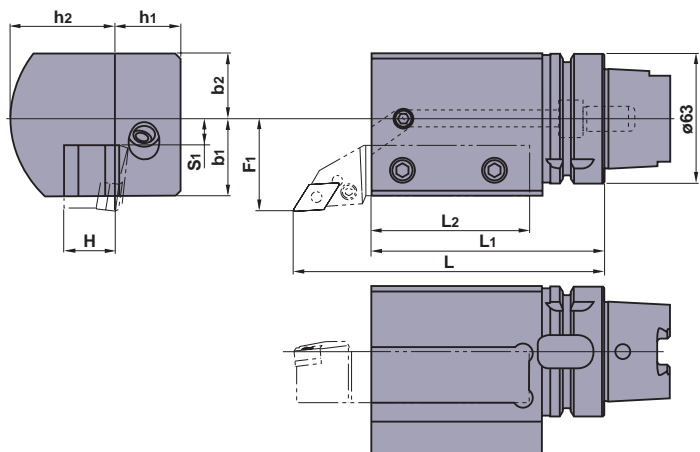
P (Pitch)	0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	
h1	0.46	0.61	0.77	0.92	1.07	1.23	1.53	1.84	2.15	2.45	2.76	
h2	0.35	0.47	0.59	0.70	0.82	0.94	1.17	1.41	1.65	1.87	2.11	
r (Corner Radius)	0.11	0.14	0.18	0.22	0.25	0.29	0.36	0.43	0.50	0.58	0.65	
Number of Passes	1	0.18	0.20	0.20	0.25	0.25	0.25	0.30	0.30	0.35	0.35	0.40
	2	0.13	0.15	0.18	0.20	0.20	0.25	0.25	0.25	0.30	0.30	0.35
	3	0.10	0.10	0.12	0.15	0.20	0.20	0.20	0.25	0.25	0.25	0.30
	4	0.05	0.10	0.12	0.15	0.15	0.15	0.20	0.20	0.20	0.25	0.25
	5		0.06	0.10	0.10	0.12	0.15	0.15	0.20	0.20	0.25	0.25
	6			0.05	0.07	0.10	0.10	0.10	0.15	0.20	0.20	0.20
	7					0.05	0.08	0.10	0.15	0.15	0.20	0.20
	8						0.05	0.10	0.10	0.15	0.15	0.15
	9							0.08	0.10	0.10	0.15	0.15
	10							0.05	0.09	0.10	0.10	0.15
	11								0.05	0.10	0.10	0.10
	12									0.05	0.10	0.10
	13										0.05	0.10
	14											0.06

(Note) The first pass causes a high load on the cutting edge.
In order to avoid damage, keep the depth of cut to 0.4-0.5mm maximum.

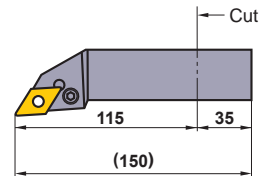
● : Inventory maintained in Japan. □ : Non stock, produced to order only.
▲ : Inventory maintained in Japan. To be replaced by new products.
(10 inserts in one case)

EXTERNAL TURNING TOOL HOLDERS


External turning • Facing



■ This holder is for 25x25 size tools.
Please shorten the tool as shown below before use.

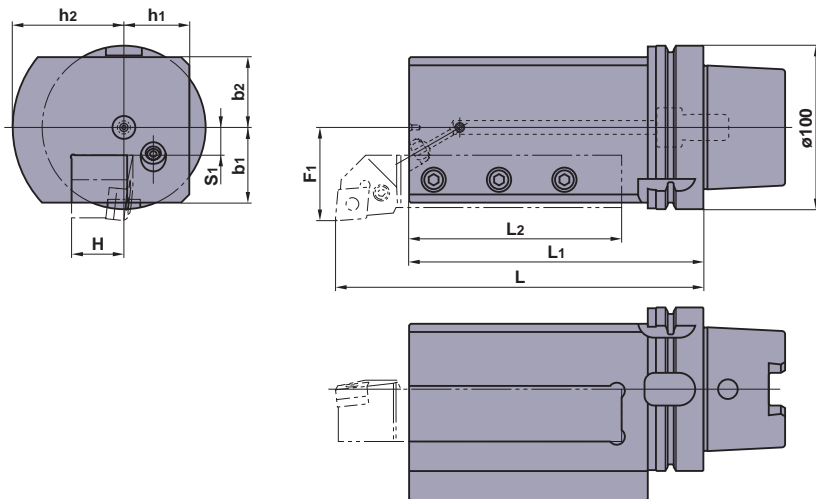


Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)										Tool Weight (kg)		
	R	L	L	L1	L2	H	h1	h2	F1	S1	b1	b2		Clamp Screw	Plug
H63TH-EV2525R/L-112	●	●	150	112	77	25	32	53	45	13	38	32	3.9	HSS12025	HGM-PT1/8


EXTERNAL TURNING TOOL HOLDERS

External turning • Facing



■ This holder is for 32x32 and 32x25 size tools.

Right hand tool holder shown.

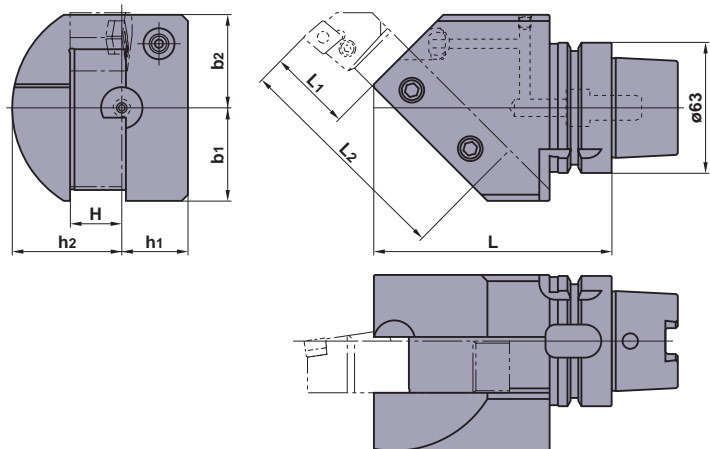
Order Number	Stock		Dimensions (mm)										Tool Weight (kg)			
	R	L	L	L1	L2	H	h1	h2	F1	S1	b1	b2		Clamp Screw	Nozzle Plug	Plug
H100TH-EV3232R/L-180	●	●	220	180	130	32	40	68	57	17	46	43	11.7	HSS14035	SNA4	HSS06006

(Note) Possible to fit a 25 x 25 tool by using a 7mm plate.

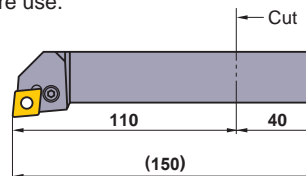
FOR MULTI-TASK MACHINES

EXTERNAL TURNING TOOL HOLDERS

External turning • Facing






■ This holder is for 25x25 size tools.
Please shorten the tool as shown below before use.



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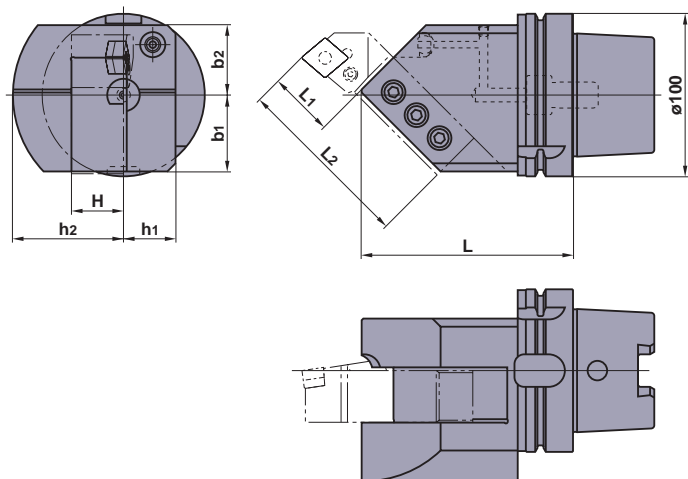
Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)								Tool Weight (kg)	 Clamp Screw	 Nozzle Plug	 Plug
	R	L	L	L1	L2	H	h1	h2	b1	b2				
H63TH-EN2525R/L-115	●	●	115	40	110	25	32	53	45	45	3.7	HSS12030	SNA4	HSS06006

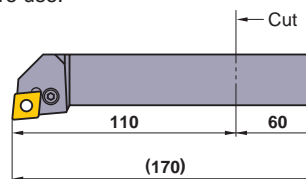
HSK-T TOOLS

EXTERNAL TURNING TOOL HOLDERS

External turning • Facing






■ This holder is for 32x32 and 32x25 size tools.
Please shorten the tool as shown below before use.



Mitsubishi Materials is licensed for production and distribution of these tools from MORI SEIKI CO., LTD under Patent No.3720202.

Right hand tool holder shown.

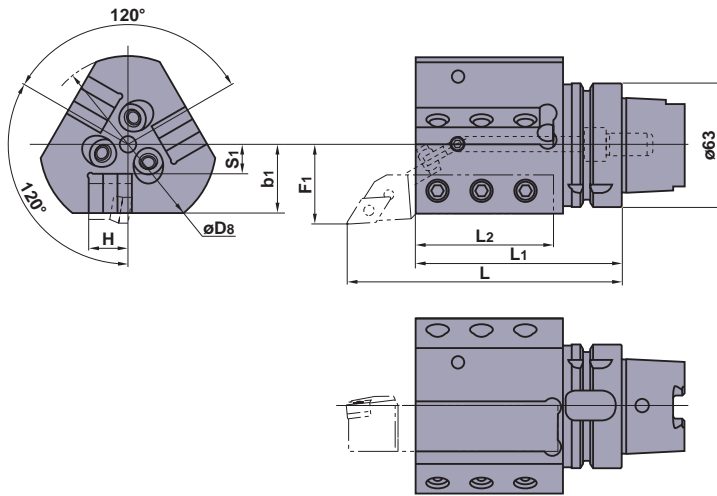
Order Number	Stock		Dimensions (mm)								Tool Weight (kg)	 Clamp Screw	 Nozzle Plug	 Plug
	R	L	L	L1	L2	H	h1	h2	b1	b2				
H100TH-EN3232R/L-130	●	●	130	40	110	32	32	68	47	43	6.6	HSS14030	SNA4	HSS06006

(Note) Possible to fit a 25 x 25 tool by using a 7mm plate.

● : Inventory maintained in Japan.

EXTERNAL TURNING TOOL HOLDERS

External turning • Facing



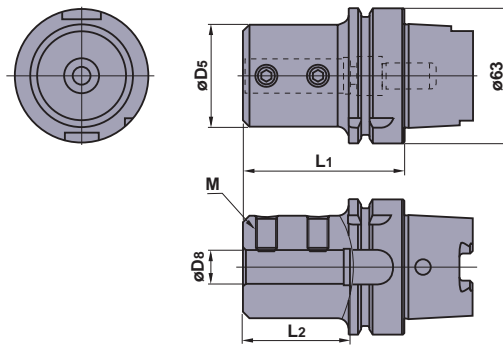
■ This holder is for 20x20 size tools.
Please shorten the tool as shown below before use.

Right hand tool holder shown.

Order Number	Stock		Dimensions (mm)								Tool Weight (kg)	Clamp Screw	Nozzle Plug	Plug
	R	L	L	L1	L2	H	D8	F1	S1	b1				
H63TH-EV2020R/L-105-3	●	●	140	105	70	20	90	40	15	35	2.9	HSS12030	HSS05012	HSS06006

BORING BAR HOLDERS

Boring



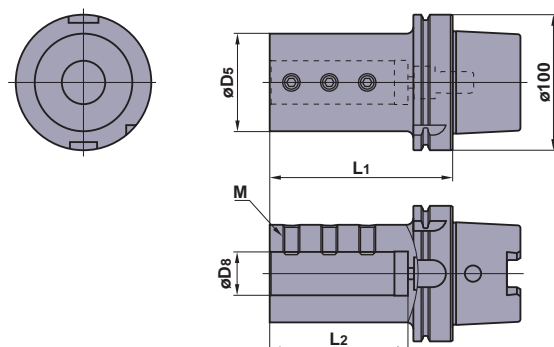
Order Number	Stock	Dimensions (mm)					Tool Weight (kg)	Clamp Screw
		D5	D8	L1	L2	M		
H63TH-B08-65	●	28	8	65	40	M8	0.9	HSS08010
-B10-70	●	35	10	70	45	M8	1.0	HSS08012
-B12-70	●	42	12	70	45	M8	1.1	HSS08012
-B16-75	●	48	16	75	50	M10	1.3	HSS10016
-B20-75	●	52	20	75	50	M10	1.4	HSS10016
-B25-83	●	62	25	83	58	M12	1.7	HSS12016
-B32-87	●	62	32	87	62	M12	1.7	HSS12016
-B40-97	●	65	40	97	72	M16	1.8	HSS16012


(Note) Please shorten a boring bar to the required shank length. This holder is for boring bars and indexable type drills.

FOR MULTI-TASK MACHINES

BORING BAR HOLDERS

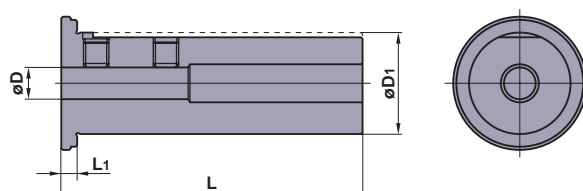
Boring




Order Number	Stock	Dimensions (mm)					Tool Weight (kg)	 Clamp Screw
		D5	D8	L1	L2	M		
H100TH-B25-120	●	62	25	120	88	12	3.9	HSS12016
-B32-135	●	72	32	135	102	12	4.8	HSS12018
-B40-150	●	82	40	150	117	16	5.9	HSS16020
-B50-180	●	92	50	180	147	16	7.7	HSS16020

(Note) Please shorten a boring bar to the required shank length. This holder is for boring bars and indexable type drills.

BORING BAR SLEEVES FOR H100TH-B32-135



Order Number	Stock	Dimensions (mm)				Tool Weight (kg)	 Clamp Screw
		D	D1	L	L1		
SL3208-90	●	8	32	95	5	0.6	HSS06008
3210-90	●	10	32	95	5	0.5	HSS08008
3212-90	●	12	32	95	5	0.5	HSS08008
3216-90	●	16	32	95	5	0.5	HSS08006
3220-90	●	20	32	95	5	0.4	HSS08005

(Note) These sleeves are only compatible with H100TH-B32-135 holder.

● : Inventory maintained in Japan.

SPARE PARTS > P001
TECHNICAL DATA > Q001